



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBT400314-7
Job Sheet 173348



Part No: RBT400314-7

Job Qty: 2 ea

Part Name: Clamp



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/28/18

Job Tracking No:

Due Date: 3/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT400314 Rev A IPP Rev A 18.02.28 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		3/15/18	0.00	0.00	Start Jp Waterjet		DC 18/03/10
100	Waterjet	2 pcs		3/15/18	0.00	0.20	Waterjet 2 OMAX		DC 18/03/10
120	Mori Seiki	2 pcs		3/16/18	0.00	2.00	MORI NV5000-2		DC 18/04/25
130	QC	2 pcs		3/16/18	0.00	0.00	QC2-2		DC 18/04/25
140	QC	2 pcs		3/16/18	0.00	0.00	QC8		DC 18-04-27
170	Outsource	2 pcs		3/16/18	0.00	0.00	Outsource4		CT 18-5-1
180	Packaging	2 pcs		3/16/18	0.00	0.00	Packaging2		AT 18/05/08
190	QC	2 pcs		3/16/18	0.00	0.00	QC6		38
200	Packaging	2 pcs		3/16/18	0.00	0.00	Packaging3-1		MAY 09 2018
210	QC21-SA	2 Ea		3/16/18	0.00	0.00	QC21		MAY 10 2018

Part Op 100 - 1-Cut blank as per Dwg Dwg Rev: A Prog Rev: A 2-Deburr if necessary
Descriptions: 120 - 1-Machine as per folio F 082 FOLIO REV: DWG REV: 2-Deburr
170 - Issue P/O to ATC: ALTECH -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required P0039765

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.375X8.000	6061T6 Bar 0.375 X 8.000	.5100 ft (.255 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B0.375X8.000	1	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Descr _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
		MRB (QSI042) Approval			
		Completed By			
		Lead hand / Supervisor Approval Verification			
		QC / QA Coordinator Approval			

DART Aerospace Ltd.
 1270 Aberdeen Street
 Hawkebury, ON K0A 1K7
 CANADA
 TEL.: 1 813 832-6200
 Email: sales@dartaero.com
 www.dartaerospace.com

Date: 03/10/18

Container No: S049857
 Part: RBT400314-7
 Job No: 173348
 Serial No/Batch: S049857
 Revision: A
 Inspector:

Root Cause			
Environment	☐	No. _____	
Design	☐	Oper _____	
Doc/Data	☐	Offse _____	
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

Cracks
 Crimp/Kink/Ripple/Wave
 Cuffs
 Crushing
 Heat Treat
 Wave/Twist in Tube
 Marks/Chatter

Broken/Damage/Defect
 Inspection Incomplete/Unqualified
 Contamination
 Countersink
 Cut Too Short
 Instructions Incomplete/Unclear
 Drill Holes

Weld
 Wrong Stock Pulled
 Out of Sequence
 Off-set
 Mislabeled
 Fit/Function
 Misaligned/off center

Positioned Wrong
 Outside Dimensions
 Over/Under tolerance
 Part Incorrect
 Part Lost/Missing
 Part Moved
 Drawing
 Finish
 Misread
 Turning Sequence

OTHER : _____

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

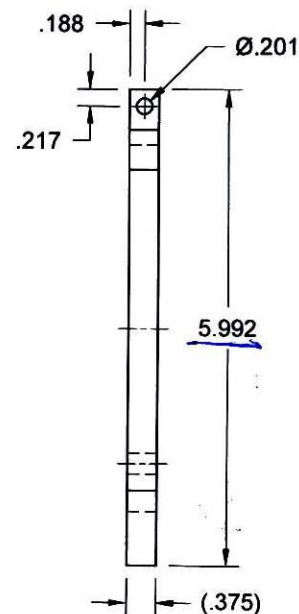
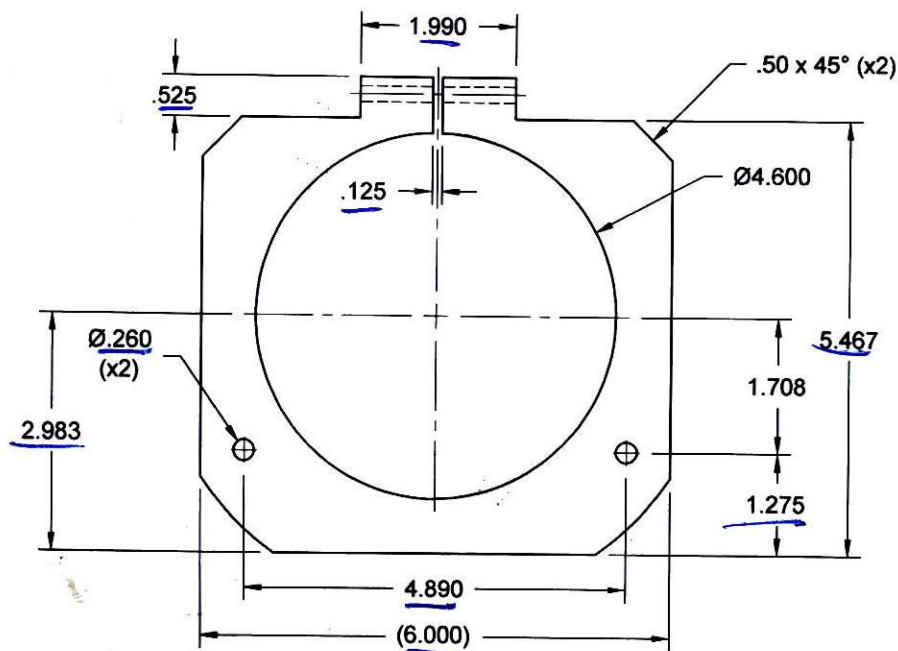
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
-	--	-	-	-



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 173348
MLC
18-02-28

(-7)
CLAMP

RED BARN MACHINE	
TITLE MAIN XSMN BACKLASH TOOL	
DWG NO. RBT400314-7	REV A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS: .005 FRACTIONS: 1/32 ANGLES: ± 5°	
METRIC REF. XXmm ± .1mm FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: CLOUGH APPROVED: <i>D. Wed</i> HEAT TREAT: CLEAR ANODIZE SPEC: MIL-A-8625F, TYPE II, CLASS I USED ON MODEL: BELL 204, 205, 212	
SCALE: NTS	DATE: 1-10-11 SHEET: 5 of 5



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039765**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO039765
PO Date: 5/1/18
Due Date: 5/4/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	176234	646.3910	Shim Issue P/O: _____ Cad Plating, CAD PLATE PER QQ-P-416, TYPE II, CLASS 2, CL2	Firmed	5/4/18	42 pcs	0 pcs	42 pcs	\$6.243333/pcs	\$262.22
						✓ 42			At 19/05/08	
2	175990	646.3912	Shim Issue P/O: _____ Cat Plating, CAD PLATE PER QQ-P-416, TYPE II, CLASS 2, CL2	Firmed	5/4/18	30 pcs	0 pcs	30 pcs	\$6.243333/pcs	\$187.30
						✓ 30x			At 19/05/08	
3	176535	PC250-810	Spring Cover -Issue P/O to Groupe Altech; PO _____ -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	5/4/18	6 pcs	0 pcs	6 pcs	\$20.00/pcs	\$120.00
						✓ 6x			At 19/05/08	
4	173348	RBT400314- 7	Plate Weldment -Issue P/O to ATG: _____ -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed	5/4/18	4 pcs	0 pcs	4 pcs	\$6.15/pcs	\$24.60
						✓ 4x			At 18/05/08	
5	173347	RBT400314- 1	Plate Weldment -Issue P/O to ATG: _____ -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed	5/4/18	2 pcs	0 pcs	2 pcs	\$25.75/pcs	\$51.50
						✓ 2x			At 18/05/08	
Grand Total:										\$645.62

Order Notes

CC.



Certificat de Conformité / Certificate of Compliance

(008887-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaitech.com

Bon de Livraison / Packing Slip

008887 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
07-May-2018		Aman		039765				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	646.3910 SHIM Rev.	646.3910 SHIM CAD YELLOW PLATE PER QQ-P-416 TYPE 2 CLASS 2 ,CL2	CADMIUM CH	42	42	0	0	0
2	646.3912 Rev.	646.3912 CAD YELLOW PLATE PER QQ-P-416 TYPE 2 CLASS 2 ,CL2	CADMIUM CH	30	30	0	0	0
3	PC250-810 Rev.	PC250-810 01 -ANO-BLACK [ANODIZE BLACK] TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	6	6	0	0	0
4	RBT400314-7 Rev.	RBT400314-7 01 -ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1 WATER SEALANT	ANODIZE CH	4	4	0	0	0
5	RBT400314-1 Rev.	RBT400314-1 01 -ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1 WATER SEALANT	ANODIZE CH	2	2	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.